

Date: Wednesday, 4/4/2007 9:03:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 31609B		
Estimate Number	: 10841		
P.O. Number	: <i>N/A</i>	Part Number	: D22493
This Issue	: 4/4/2007	S.O. No. :	<i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2249 REV. E
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31485B	Drawing Revision	: E
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	:	Due Date	: 4/11/2007
Checked & Approved By	:	Qty:	10 Um: Each
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now On Waterjet 07-03-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1470 sf(s)/Unit Total : 1.4700 sf(s)

304/316 .063 Sheet

Batch: *H103961**SAD 07/04/14**(10)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: *E*Prog Rev: *E**SM 07/04/20*
*SAD 07/04/14**(10)*

2-Deburr if necessary

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/04/14**(10)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*MS 07/04/15**(10)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D2249

*FC 07/04/24**(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31609B

Part Number: D22493

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/04/24 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 21

10/04/25 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/04/25

Job Completion



U 10/04/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31609B
Description: Base Plate		Part Number:	D2249-3
Inspection Dwg: D2249	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.261	+0.006/-0.001	Ø0.262	✓		Vern	
4.44	+/-0.030	4.44	✓		Vern	
3.690	+/-0.010	3.689	✓		Vern	
2.400	+/-0.010	2.404	✓		Vern	
3.20	+/-0.030	3.21	✓		Vern	
0.375	+/-0.010	0.378	✓		Vern	
0.400	+/-0.010	0.402	✓		Vern	

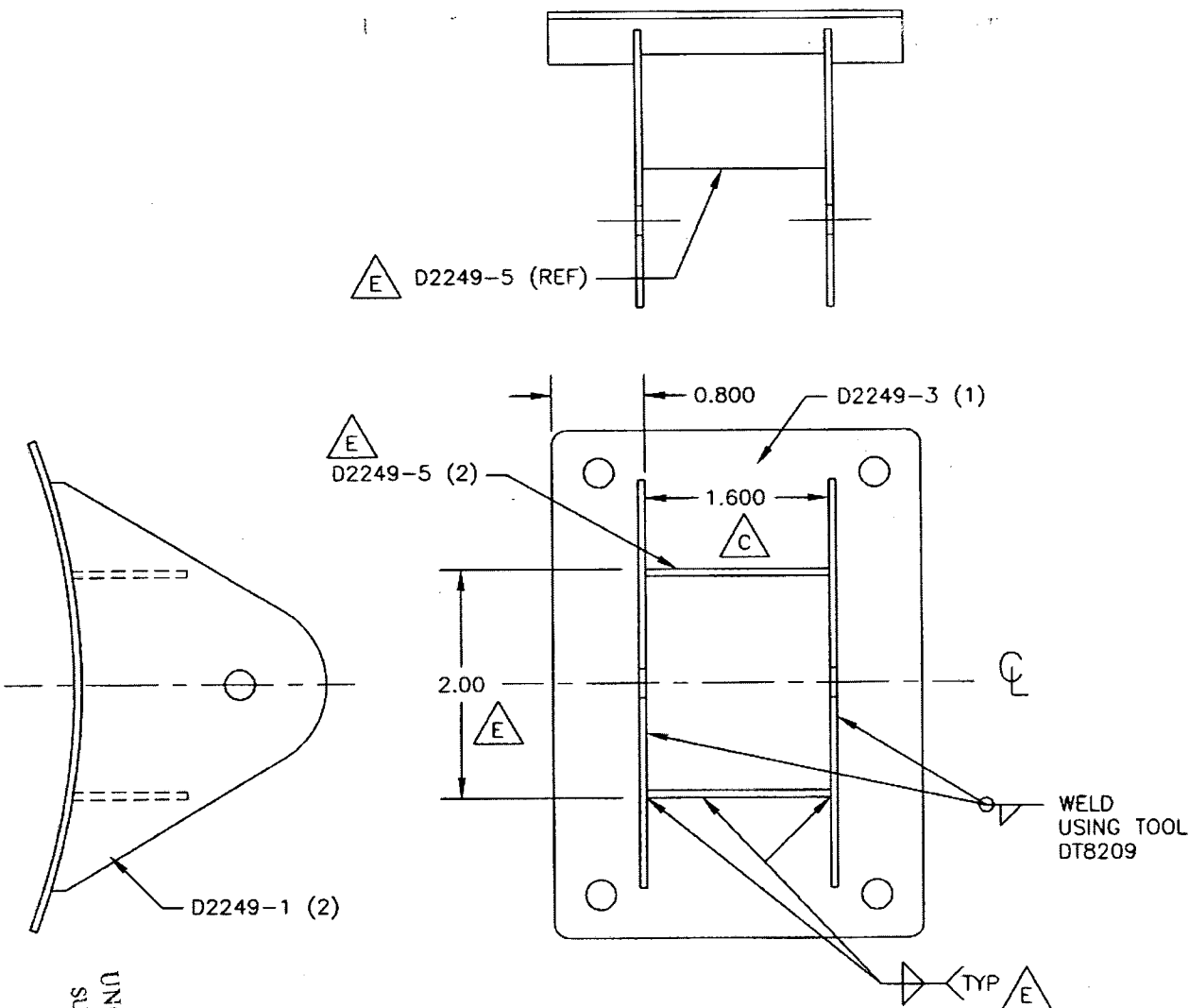
Measured by:	SAN	Audited by:	MS	Prototype Approval:	N/A
Date:	07/04/14	Date:	07/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.23	New Issue	KJ/JLM	



RELEASED
99.10.12 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
AE	RF		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 4
KE	RF	D2249	
DATE	TITLE	SCALE	
99.09.20	FITTING	NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (ISR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

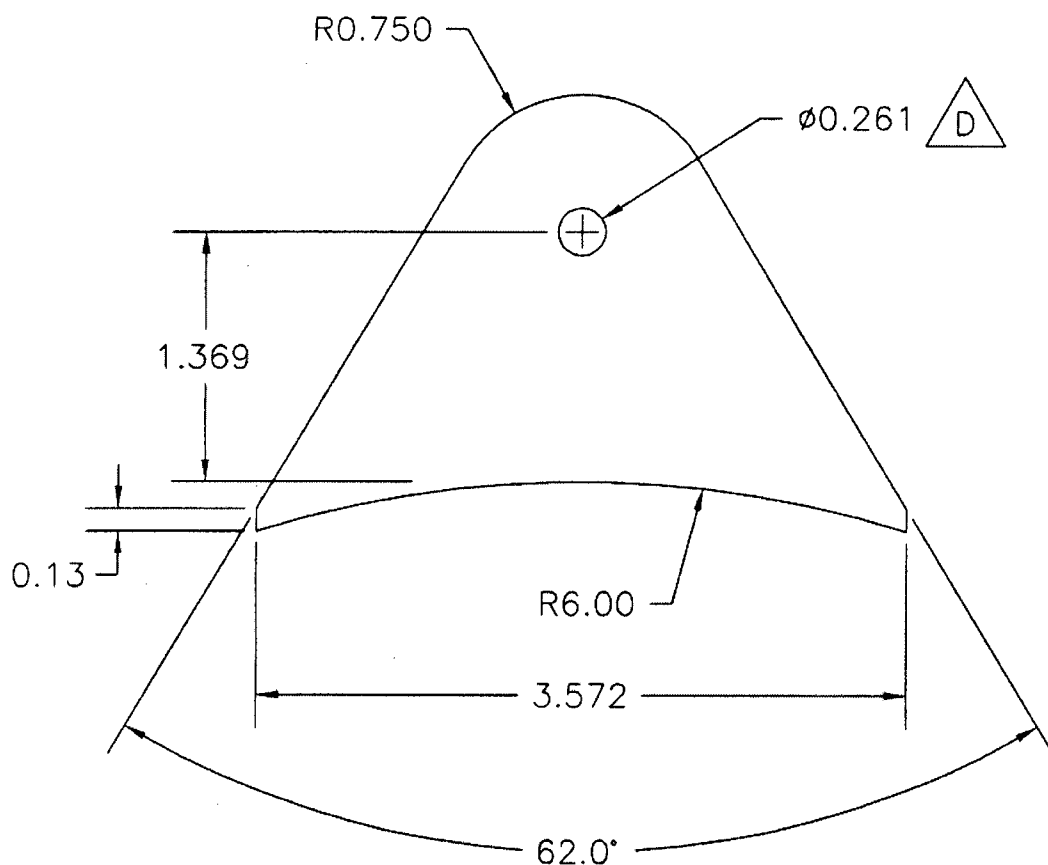
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 31603B



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 *KE*



D2249-1 LUG


MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

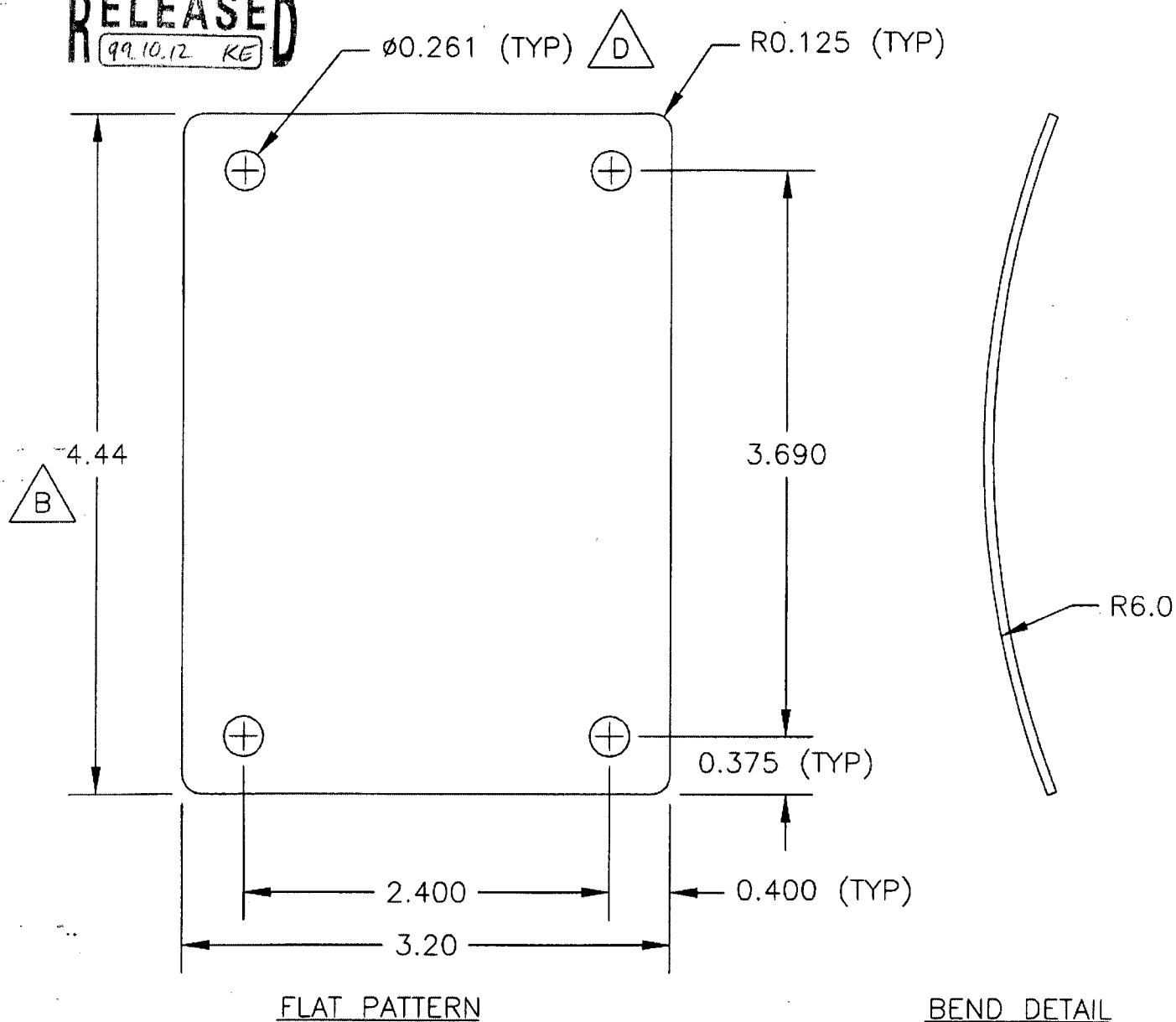
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NOTED TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31609B



DESIGN RE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE	APPROVED 	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

BEND DETAIL

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WORK ORDER

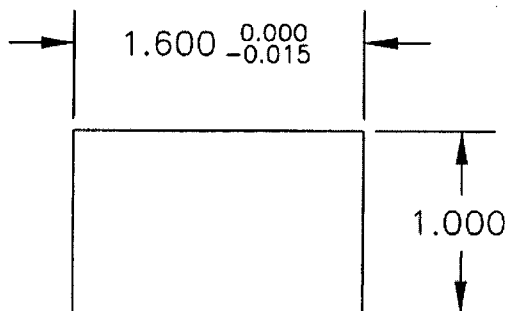
WORK ORDER

316095



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
19.10.12 *KE*



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DO NOT DO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31609B